

Date: Wednesday, 01/04/2009 9:10:17 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 46772
Estimate Number : 11054
P.O. Number :
This Issue : 01/04/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 45210
Written By :
Checked & Approved By : JUL 09.04.01
Comment : Est A05.09.13 New issue KJ/JLM

Drawing Name : NUT PLATE ASSEMBLY
Part Number : D2873045
Drawing Number : D2873 REVA
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 15/04/2009 Qty: 20 Um: Each

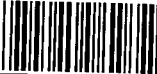
Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0375X01000 6061T6 BAR .375 x 1.00



Comment: Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B0.375x01.000)

Identify for D2873-5

Batch: M110829

DJP 09/04/03

2.0 BAND SAW BAND SAW



(20)

Comment: BAND SAW

Cut blanks: 1.000" x 0.375" x 2.700" long

DJP 09/04/03

22

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-5

Dwg Rev A Folio Rev A

(PTO)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



J.F. 09/04/04

(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/04/04

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2873-045 PAR #: N/A Fault Category: Prod/Machined ^{TAB} NCR ☒ Yes ☐ No DQA: D Date: 05/05/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/05/06

NCR: <u>46772</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/04</u>	<u>3.0</u>	Holes 3/16" are .3330 <u>3/16" Holes are over tolerance for 2 parts.</u> <u>Incorrect size drill 0.333 mounted in collet during Set-up.</u> <u>R.C. operator set-up error.</u>	<u>[Signature]</u>	<u>2 parts scrap</u> <u>Replace qty 2 H 110829</u>	<u>J.F</u> <u>09/04/04</u>	<u>[Signature]</u> <u>09/04/06</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Wednesday, 01/04/2009 9:10:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 46772

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

10.0

MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

4

MS20426AD4-6

Rivet

M105144

11.0

MS21075L5

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

2

MS21075L5

Nut Plate

M110916 (212)

M111127 (19K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/04/2009 9:10:18 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 46772

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/08 (20)
counters
5 09/04/08 (20)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *X tube assy*

(x20)

ET 09-05-05

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06
mf

Job Completion



09-05-05

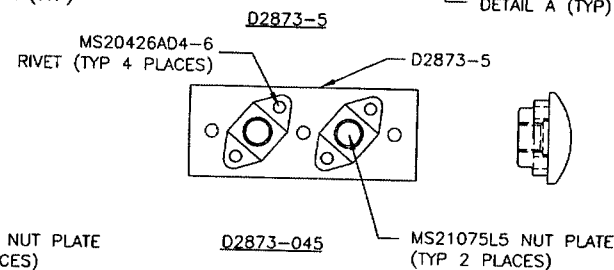
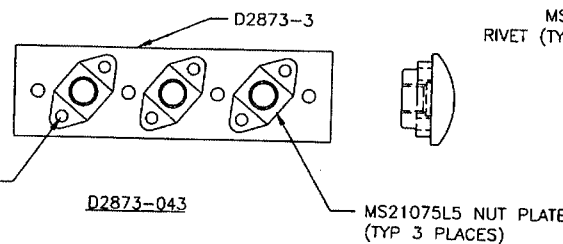
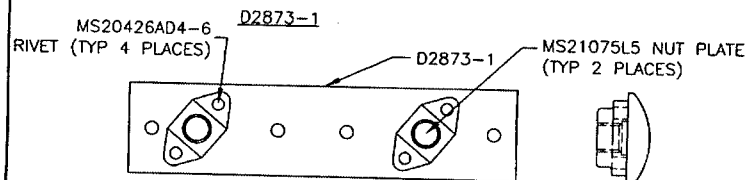
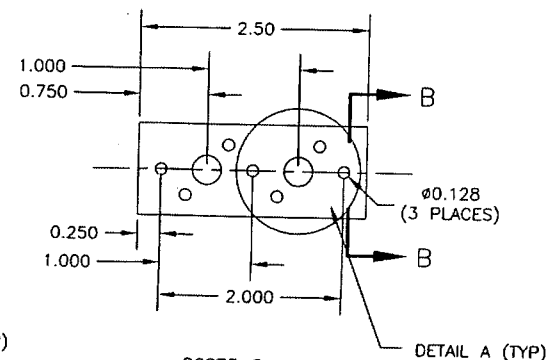
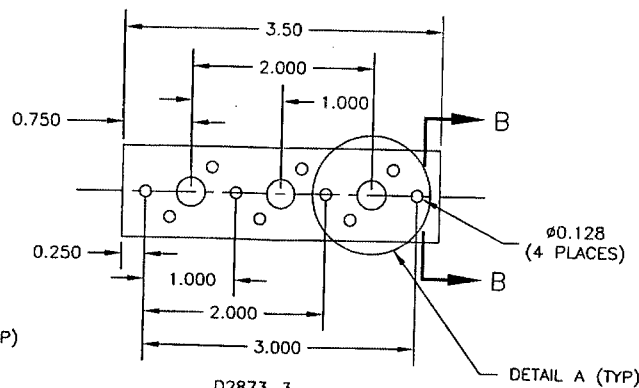
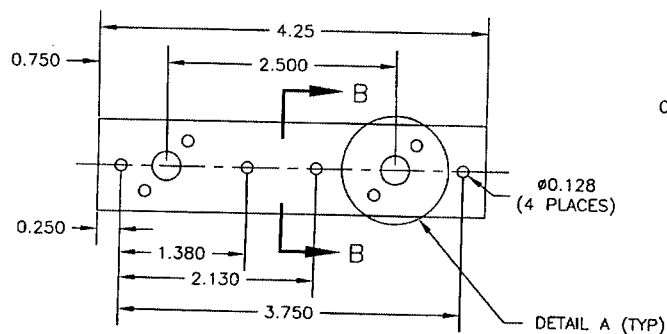
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2873-1/-3/-5 RADIUS BLOCK

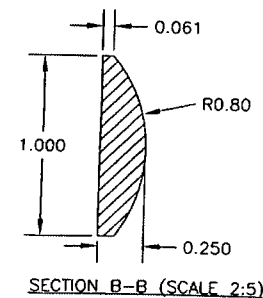
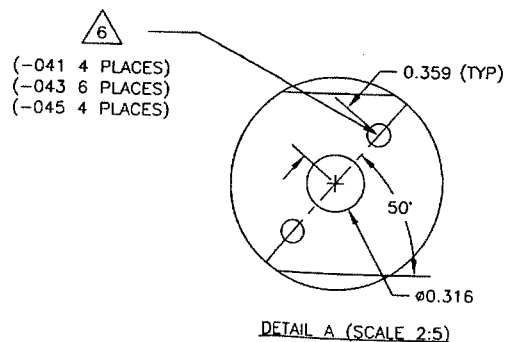
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100"

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	1	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	DS	APPROVED DS
DATE	05.07.26	TITLE RADIUS BLOCK
		DART AEROSPACE LTD WILKESBURY, ONTARIO, CANADA
		D2873
		REV. A
		SHEET 1 OF 1
		SCALE 4:5

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